

Date: Monday, 12/01/2009 2:37:56 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD LEG ASS'Y
Job Number : 44681	
Estimate Number : 13175	
P.O. Number :	Part Number : D3684047
This Issue : 12/01/2009 S.O. No. :	Drawing Number : D3684 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 38482	Material :
Written By :	Due Date : 23/02/2009 Qty: <u>8</u> Um: Each
Checked & Approved By : <u>JUD 09.01.13</u>	
Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2.0	D36881	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit **Total:** 10.0000 Each(s)
 STUD
 batch B44823 B45670

3.0	D36891	SLEEVE
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Comment: Qty.: 1.0000 Each(s)/Unit **Total:** 10.0000 Each(s)
 SLEEVE
 batch 44825

4.0	D36911	STUD
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Comment: Qty.: 1.0000 Each(s)/Unit **Total:** 10.0000 Each(s)
 STUD
 batch B45495

5.0	D36921	SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit **Total:** 40.0000 Each(s)
 SPACER
 batch B45672

9/4/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3684-047 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/28

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44681</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.04.24	2	Qty 1) D3684-1 ^{D3693-1} <u>CP</u> STUD HAS OVER SIZED HOLE	<u>CP</u> 09.04.24 pu QSI 042	SCRAP STUD AND REPLACE D3693-1 (+L) B # 45723 FF	FF 09/04/27	S 09/04/27	<u>CP</u> 09.04.24 pu QSI 042	S 09/04/27

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LEG ASS'Y

Job Number: 44681

Part Number: D3684047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36931

Rod End Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rod End Bearing

batch 44826

SP

7.0

AN3C12A

Bolts



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolts

batch 1110552

SP

8.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

batch 1111041

SP

9.0

NAS509L12C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nuts

batch 1106993

SP

10.0

NAS50912C

Nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nuts

batch 1106993

9/4/16

SP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound on thread and assemble as per dwg D3684

FF 09-04-22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/09/04/22 (X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD LEG ASS'Y

Job Number: 44681

Part Number: D3684047

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



8x

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: store

9/4/27

SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

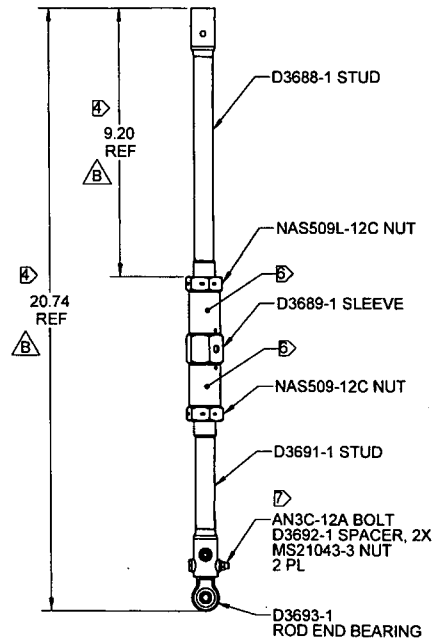
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-47 FWD LEG ASSEMBLY

RELEASED
08/12/57

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.15 lbs
- 6) USE TECTYL 502C CLASS 1, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	Q	DRAWING NO. D3684	REV. B SHEET 4 OF 5
MFG. APPR.	Q	TITLE TRIPOD MOUNT ASSY	SCALE NTS
APPROVED	Q	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	
DE APPR.	Q		
DATE	08.11.24		